



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3571-1

Job Sheet 199318



Part No: D3571-1

Job Qty: 15 pcs

Part Name: Guide



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/19/19

Job Tracking No:

Due Date: 8/26/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 07-02-01 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	15 pcs		8/26/19	0.00	0.28	Bandsaw - 1		am L 19/08/19
110	HAAS 4 Axis - B4B	15 pcs		8/26/19	0.40	10.14	HAAS - 1 - B4B		am L 19/09/18
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	15 pcs		8/26/19	0.00	0.00	QC 2 - 1		am L 19/09/18
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		



Container No: S214155



Part: D3571-1

Job No: 199318

Serial No/Batch: S214155

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/17/19

Plex 8/19/19 11:58 AM Dart.Renwick.Jennifer

D56

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

https://www.plexonline.com/6374c25a-3eb0-4713-8e26-83e75e72090b/Plexus_Control/Report_Viewer_2.asp?URL=https://www.plexonline.com/6374c... 2/6

8/19/2019

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150	Powdercoat - 3 Grey Sand - B4B	15 pcs	8/26/19	0.00	0.30	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
160	QC 3	15 pcs	8/26/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	15 pcs	8/26/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	

BL 19-8-20

START: 9:50 O.V.T: 320° FINISH: 10:20

DAS 40

SEP 23 2019 9:30

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Packaging 3 - 5 - B4B	DAS 28 9-89
Packaging 3 - 6 - B4B	
Packaging 3 - 7 - B4B	
Packaging 3 - 8 - B4B	
Packaging 3 - 9 - B4B	
Packaging 3 - 10 - B4B	
Packaging 3 - 11 - B4B	
Packaging 3 - 12 - B4B	
Packaging 3 - 13 - B4B	
Packaging 3 - 14 - B4B	
Packaging 3 - 15 - B4B	
Packaging 3 - 16 - B4B	
Packaging 3 - 17 - B4B	
Packaging 3 - 18 - B4B	
Packaging 3 - 19 - B4B	
Packaging 3 - 20 - B4B	
Packaging 3 - 21 - B4B	
Packaging 3 - 22 - B4B	
Packaging 3 - 23 - B4B	
Packaging 3 - 24 - B4B	
Packaging 3 - 25 - B4B	
Packaging 3 - 26 - B4B	
Packaging 3 - 27 - B4B	
Packaging 3 - 28 - B4B	
Packaging 3 - 29 - B4B	
Packaging 3 - 30 - B4B	
Packaging 3 - 31 - B4B	
Packaging 3 - 32 - B4B	
Packaging 3 - 33 - B4B	
Packaging 3 - 34 - B4B	
Packaging 3 - 35 - B4B	
Packaging 3 - 36 - B4B	

180 QC 21 - SA

15
pcs

8/26/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

SEP 23 2019

DAS

70

9-89

Part Op 100 - Cut blank 2.90 " long

Descriptions: 110 - (HAAS CNC Vertical Machine), 1- Mill as per Folio FA675Rev: FA & Dwg D3571 Rev: A 2-Deburr per dwg D3571

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3), START TIME: _____

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X01.500	6061-T6 Bar .750 X 1.50	3.6150 ft (.241 ea)	100-Bandsaw - 1	<u>S204135</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.750X01.500	4	98	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hook	5.4500inches $\pm$ 0.0300	5.4800 5.4200		
2	Hook	0.2500inches $\pm$ 0.0300	0.2800 0.2200	Radius	
3	Hook	0.2800inches $\pm$ 0.0300	0.3100 0.2500	Radius	
4	Hook	30.0000inches $\pm$ 0.5000	30.5000 29.5000	Degrees	
5	Hook	0.3900inches $\pm$ 0.0300	0.4200 0.3600	Radius	
6	Hook	10.0000inches $\pm$ 0.5000	10.5000 9.5000	Degrees	
7	Hook	0.2800inches $\pm$ 0.0300	0.3100 0.2500	Radius	
8	Hook	34.0000inches $\pm$ 0.5000	34.5000 33.5000	Degrees	
9	Hook	0.3900inches $\pm$ 0.0300	0.4200 0.3600		
10	Hook	0.8600inches $\pm$ 0.0300	0.8900 0.8300		
11	Hook	0.2000inches $\pm$ 0.0100	0.2100 0.1900		
12	Hook	2.2900inches $\pm$ 0.0300	2.3200 2.2600		
13	Hook	0.1600inches $\pm$ 0.0300	0.1900 0.1300		
14	Hook	70.0000inches $\pm$ 0.5000	70.5000 69.5000	Degrees	
15	Hook	40.0000inches $\pm$ 0.0300	40.0300 39.9700		
16	Hook	2.6100inches $\pm$ 0.0300	2.6400 2.5800		
17	Hook	0.1740inches $\pm$ 0.0100	0.1840 0.1640		

see FAI
a Haas
JFC 2019-09-17

8/19/2019

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

18	Hook	60.0000inches $\pm$ 0.5000	60.5000 59.5000	Degrees
19	Hook	0.2040inches $\pm$ 0.0050 - 0.0010	0.2090 0.2030	Diameter
20	Hook	0.3740inches $\pm$ 0.0100	0.3840 0.3640	
21	Hook	0.7480inches $\pm$ 0.0100	0.7580 0.7380	
22	Hook	0.3500inches $\pm$ 0.0300	0.3800 0.3200	
23	Hook	0.7500inches $\pm$ 0.0050	0.7550 0.7450	
24	Hook	3.2500inches $\pm$ 0.0050	3.2550 3.2450	
25	Hook	0.5500inches $\pm$ 0.0100	0.5600 0.5400	
26	Hook	0.1300inches $\pm$ 0.0300	0.1600 0.1000	Radius
27	Hook	0.0200inches $\pm$ 0.0300	0.0500 (0.0100)	Radius
28	Hook	1.9700inches $\pm$ 0.0300	2.0000 1.9400	
29	Hook	2.4300inches $\pm$ 0.0300	2.4600 2.4000	
30	Hook	1.8700inches $\pm$ 0.0300	1.9000 1.8400	
31	Hook	0.0500inches $\pm$ 0.0050 - 0.0010	0.0550 0.0490	

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DART AEROSPACE LTD		Work Order: 199318
Description: Guide		Part Number: D3571-1
Inspection Dwg: D3571	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.696	✓		vern	mm-l-05
Ø1.00 Depth 100	+/-0.010	.997 x .05	✓		↓	
2.75	+/-0.030	2.749	✓			
1.38	+/-0.030	1.372	✓			
1.25	+/-0.030	1.253	✓			
0.63	+/-0.010	.623	✓			
0.031 chamfer	+/-0.010	0.030	✓			
Ø0.500	+0.006/-0.001	.502	✓			
Ø0.201	+0.005/-0.001	.202	✓			
R0.25	+/-0.030	.25	✓			
0.260	+0.000/-0.010	.255	✓		RG vern	mm-l-05
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	.390 x 100	✓		↓	
0.125	+/-0.010	.126	✓			
2.250	+/-0.010	2.240	✓			
0.250	+/-0.010	.255	✓			
0.188	+/-0.010	.185	✓			
0.063 chamfer	+/-0.010	.063	✓		↓	

Measured by: mm-l	Audited by: [Signature]	Prototype Approval:	N/A
Date: 19/09/18	Date: 19/09/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM [Signature]	[Signature]